

Date: Tuesday, 2/26/2008 8:00:01 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 37610
 Estimate Number : 10278
 P.O. Number :
 This Issue : 2/26/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3121141
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3121 REV E
 Previous Run : 36663 Drawing Revision : E
 Written By : Due Date : 3/28/2008 Qty: 24 Um: Each
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: Pick: A 04.02.18 New issue KJ/DS
 Est Rev: B ECN 1060 07-11-12 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M174B1000X02000 17-4 SS Bar



Comment: Qty.: 0.5775 f(s)/Unit Total: 13.8600 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.000x02.000)

Identify for D3121-111

Batch: *101422* *M 1024.76 24 parts*
DIP 08/02/27

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 6.600" long

DIP 08/02/27

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111

2-Deburr

3-Scribe batch number

DIP

SF 08/02/29

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



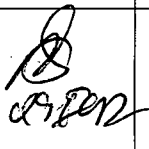
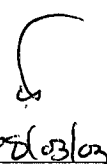

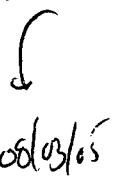
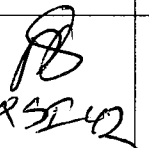
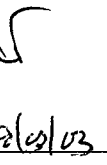


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-141 PAR #: N/A Fault Category: Prod / Machine Part NCR: Yes No DQA: D Date: 08/04/04
D412-698 QA: N/C Closed: D Date: 08/24/04

NCR: 37610		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/01	3.0	^{jig} Part parts was Not install Correctly. The part came of the jig. R.C. Method		Make Sure the parts are clamp strongly. <u>Qty x2</u> Scrap and Destroy and Reflash Batch # <u>19478</u>	DJP 08/03/03			
08/03/03	# 30	one Blank was cut too short. R.C. Hammerston		Scrap and Destroy Qty <u>(x1)</u>	DJP 08/03/03			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:00:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 37610

Part Number: D3121141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/03/05

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt B 37478

(6)

B 37879

(18) 08/04/01

(24)

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B 37475

(18)

B 37750

(6) 08/04/01

(24)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

mf 08/04/01 x24

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(C) 08/04/01 x24

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

233

08/04/01 (24)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



mf 08-04-02
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 37610
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.392	✓			
0.75	+/-0.030	0.7515	✓			
0.375	+/-0.010	0.375	✓			
2.14	+/-0.030	2.130	✓			
1.96	+/-0.030	1.964	✓			
0.280	+/-0.010	0.277	✓			
3.330	+/-0.010	3.325	✓			
3.630	+/-0.010	3.625	✓			
R0.25	+/-0.030	0.259	✓			
R0.375	+/-0.010	0.375	✓			
Ø0.201	+0.005/-0.000	Ø0.201	✓			
0.100	+/-0.010	0.110	✓			
4.580	+/-0.010	4.577	✓			
6.18	+/-0.030	6.192	✓			
5.89	+/-0.030	5.888	✓			
0.080	+/-0.010	0.079	✓			
0.300	+/-0.010	0.299	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	0.250	✓			
0.130	+/-0.010	0.130	✓			
0.664	+/-0.010	0.664	✓			
0.381	+/-0.010	0.390				
0.201	+/-0.010	0.203	✓			
0.400	+/-0.010	0.396	✓			
0.580	+/-0.010	0.588	✓			
100°	+/-0.1°	100°	✓			
0.032	+0.000/-0.010	0.024	✓			

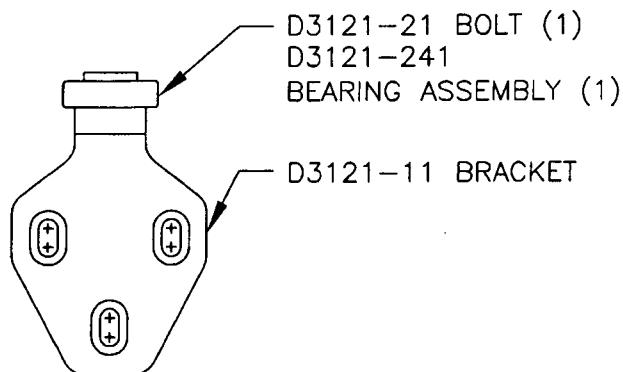
Measured by: DJT	Audited by: SMK	Prototype Approval: N/A
Date: 08/03/01	Date: 08/03/01	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	

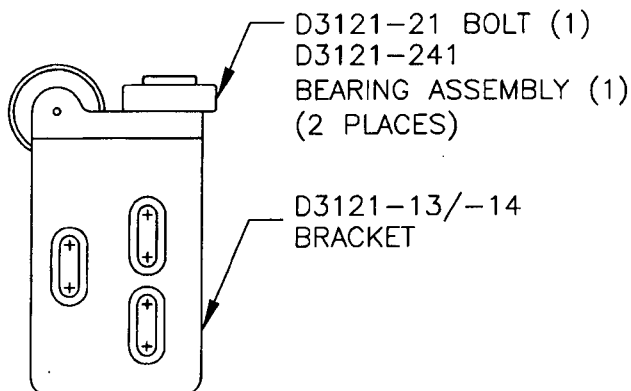


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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

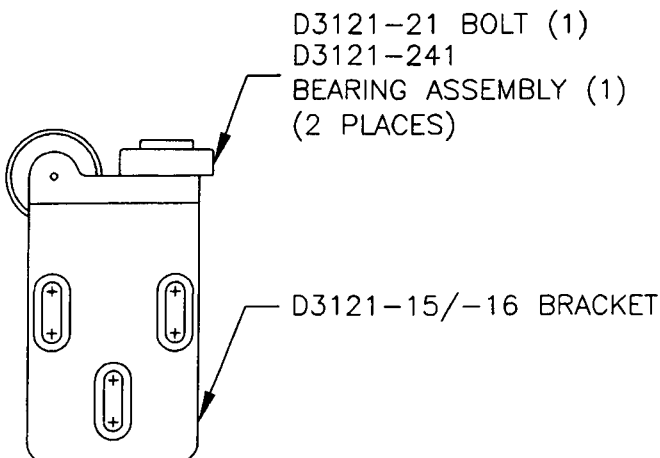
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D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

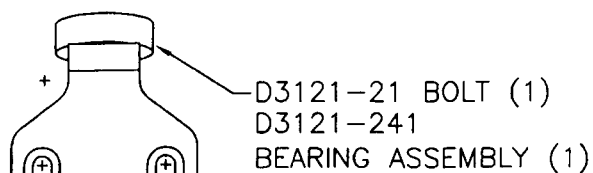
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

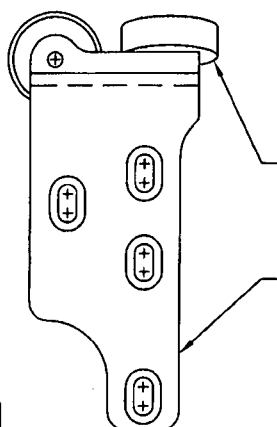


D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

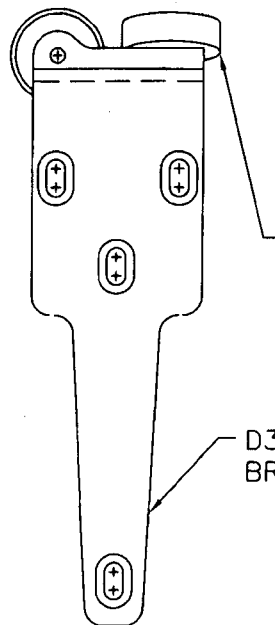
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D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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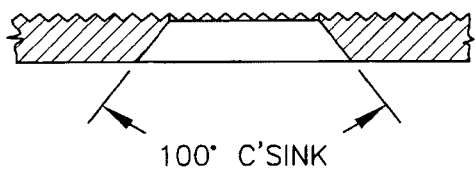
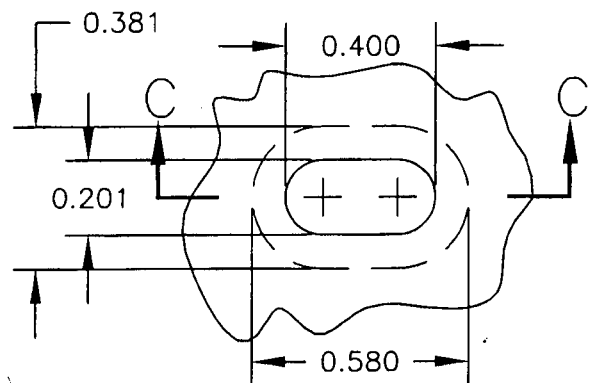
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

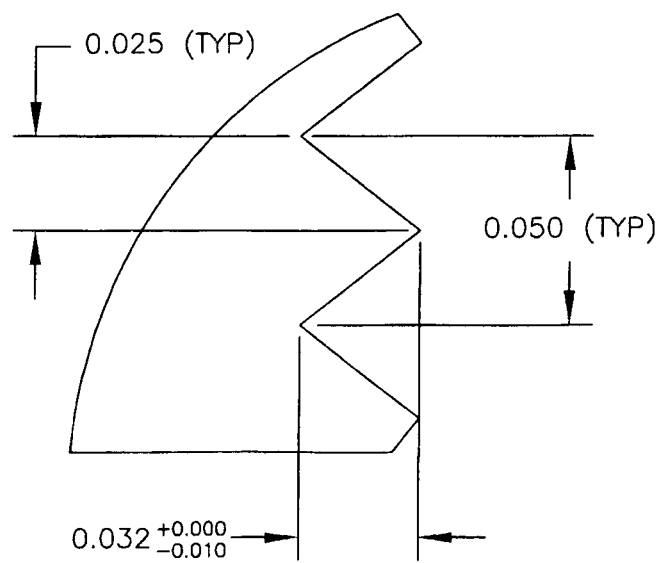
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

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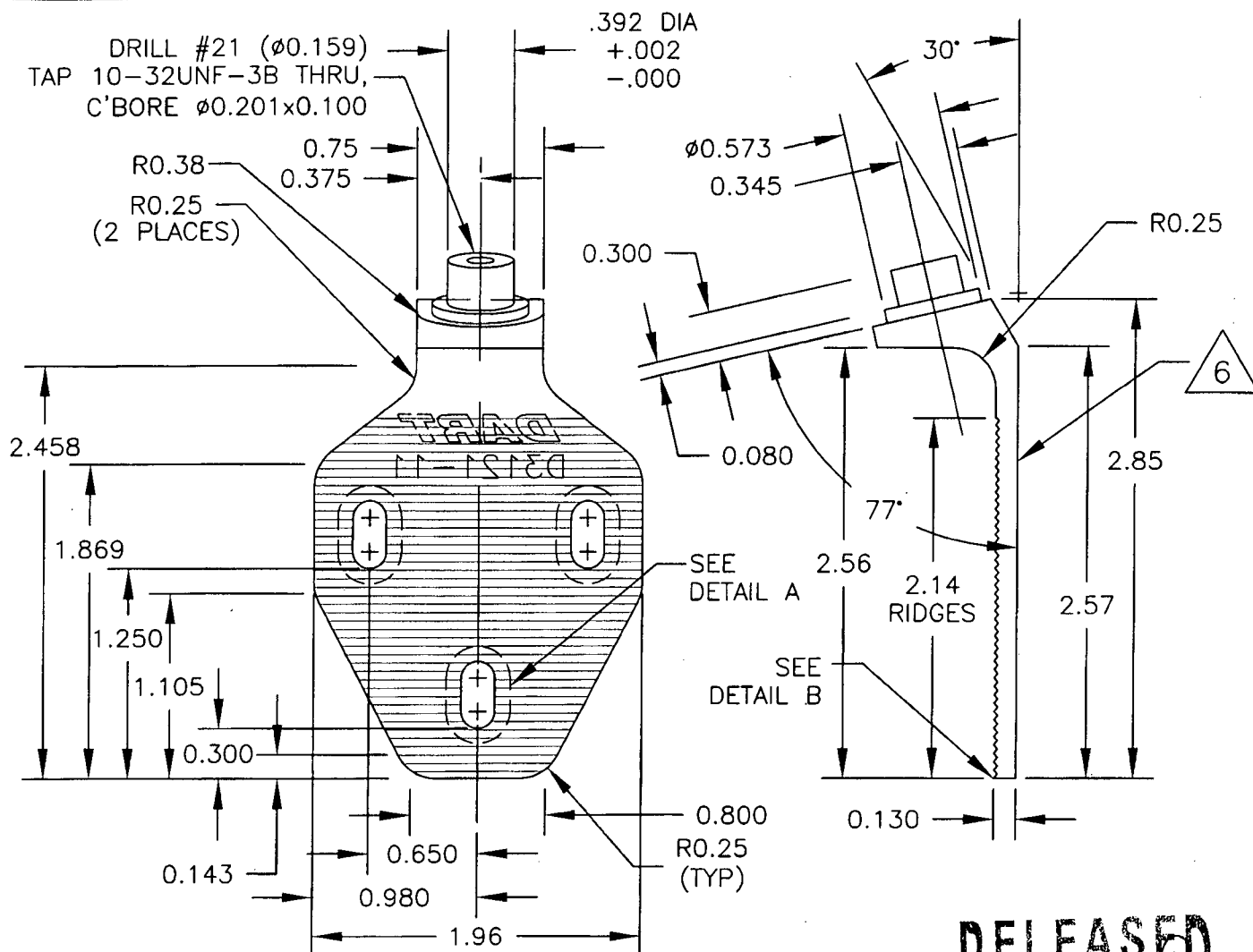
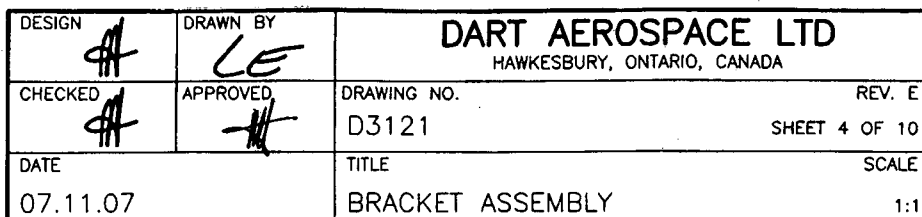
DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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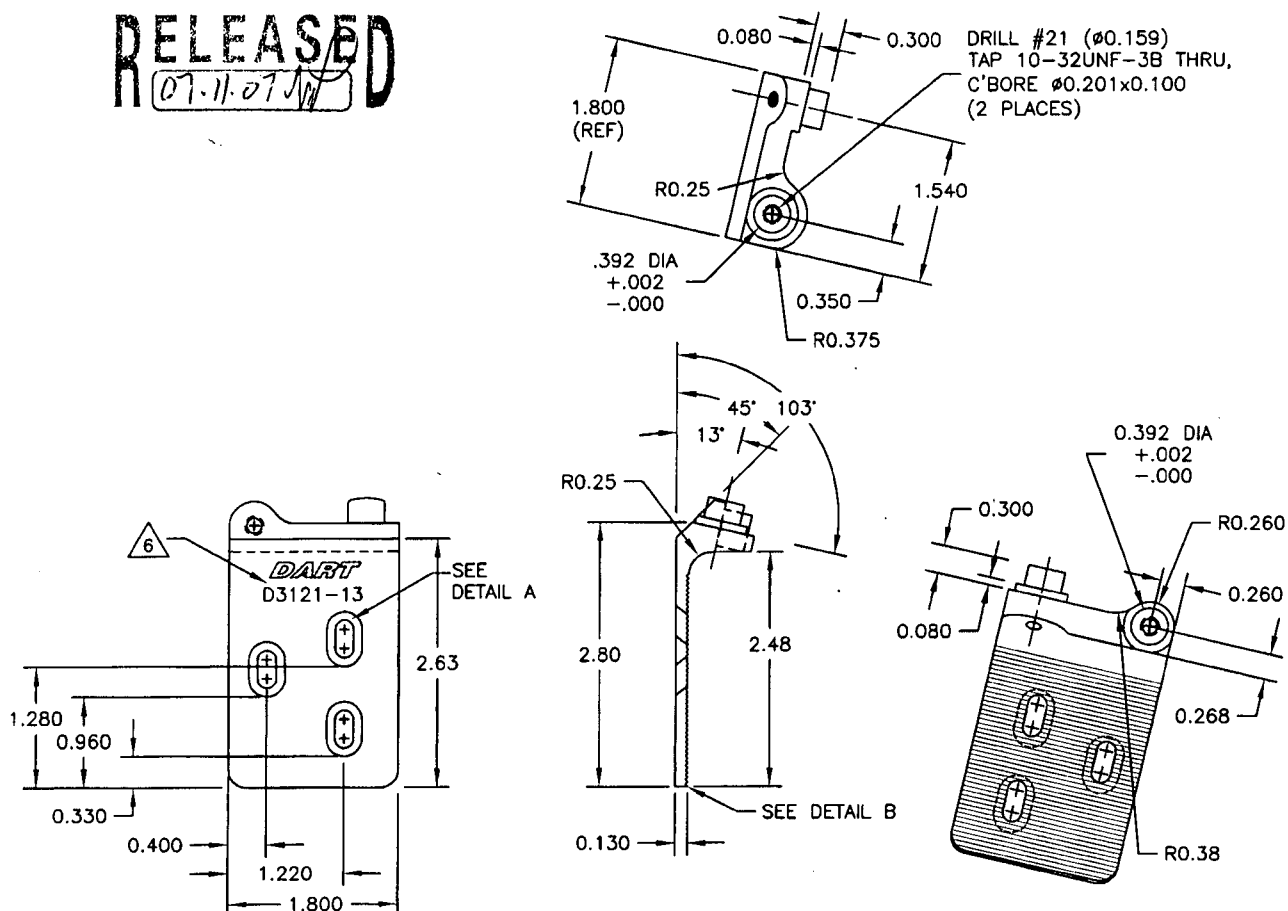
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

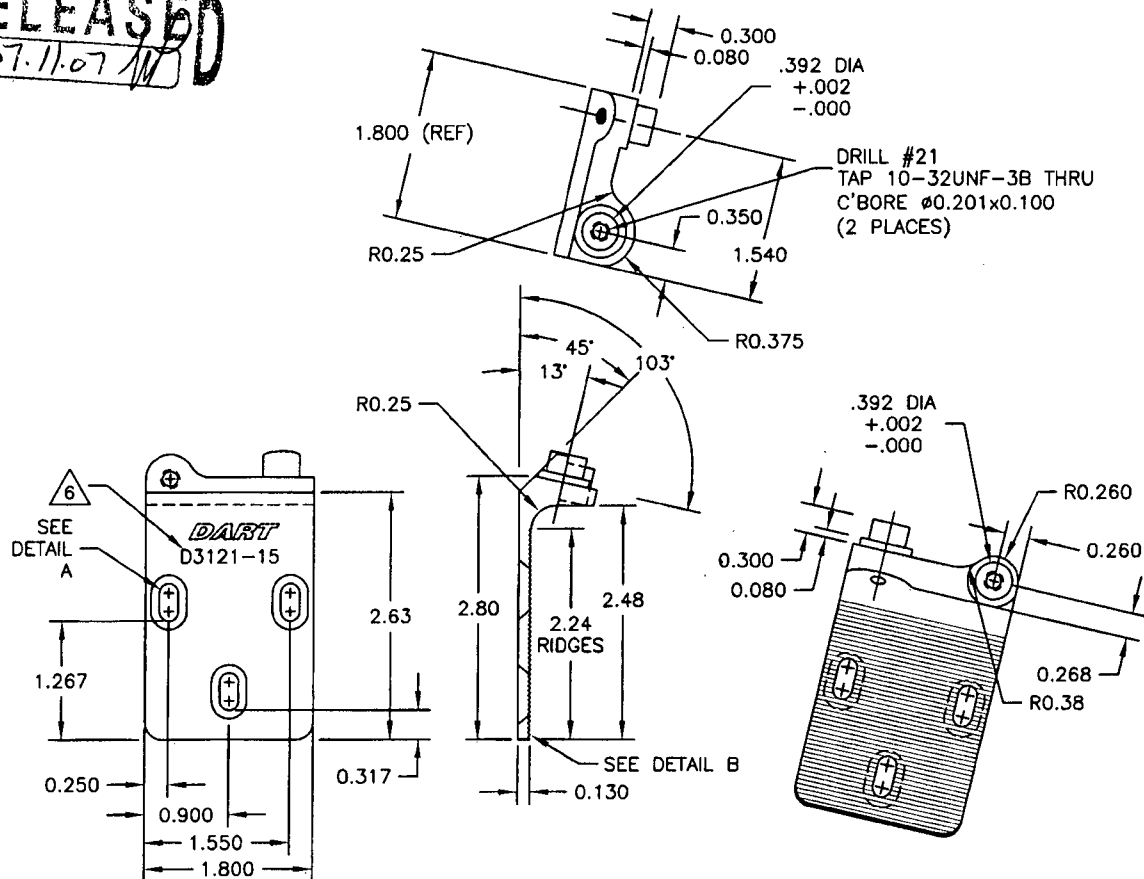
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

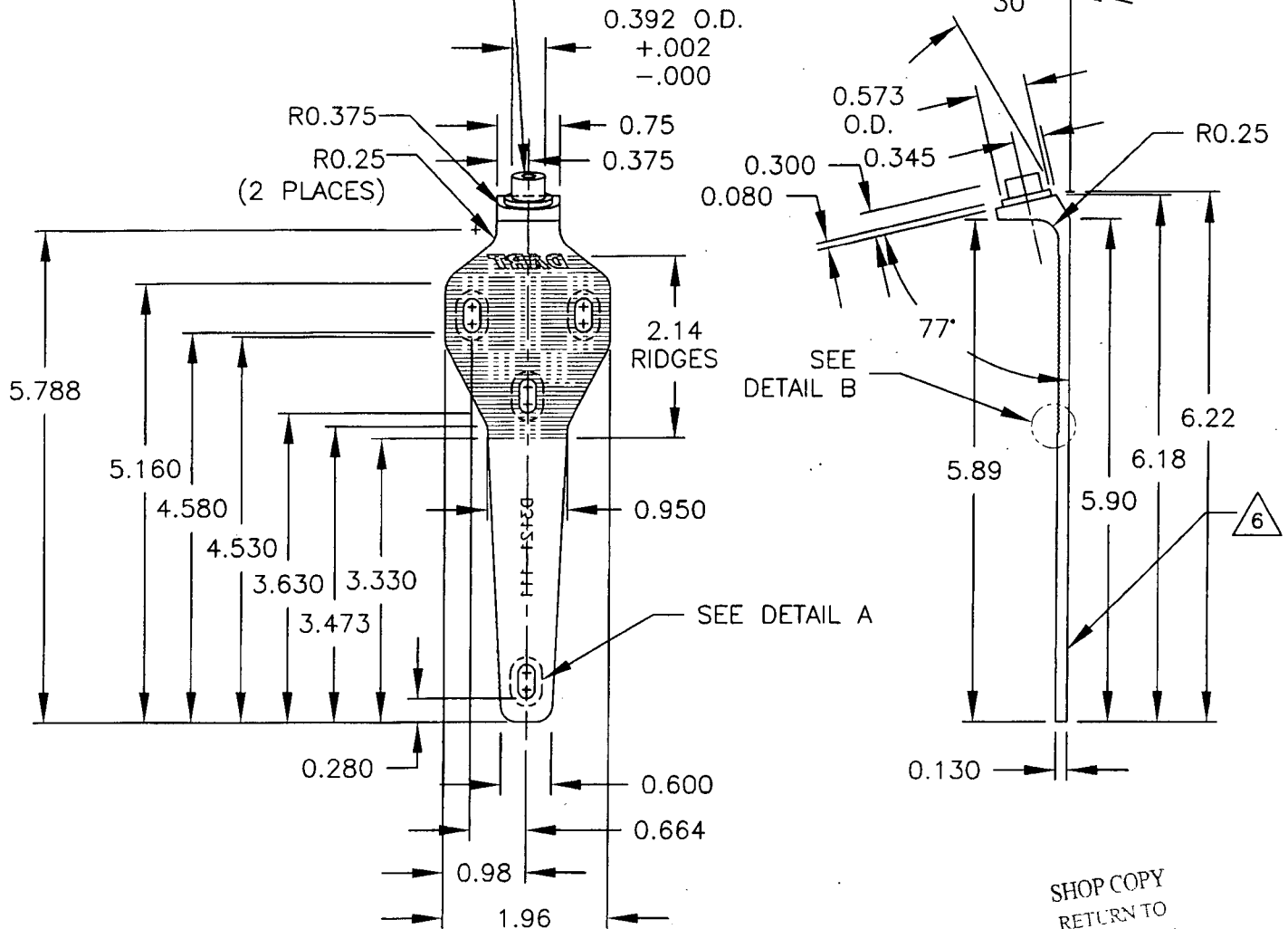
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

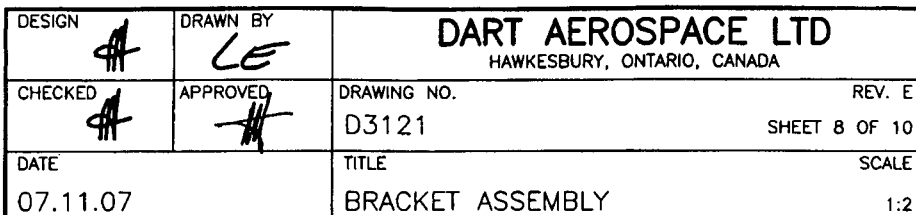
RELEASED
07.11.07/WDRILL #21 ($\phi 0.159$)
TAP 10-32 UNF-3B THRU
C'BORE $\phi 0.201 \times 0.100$ **D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

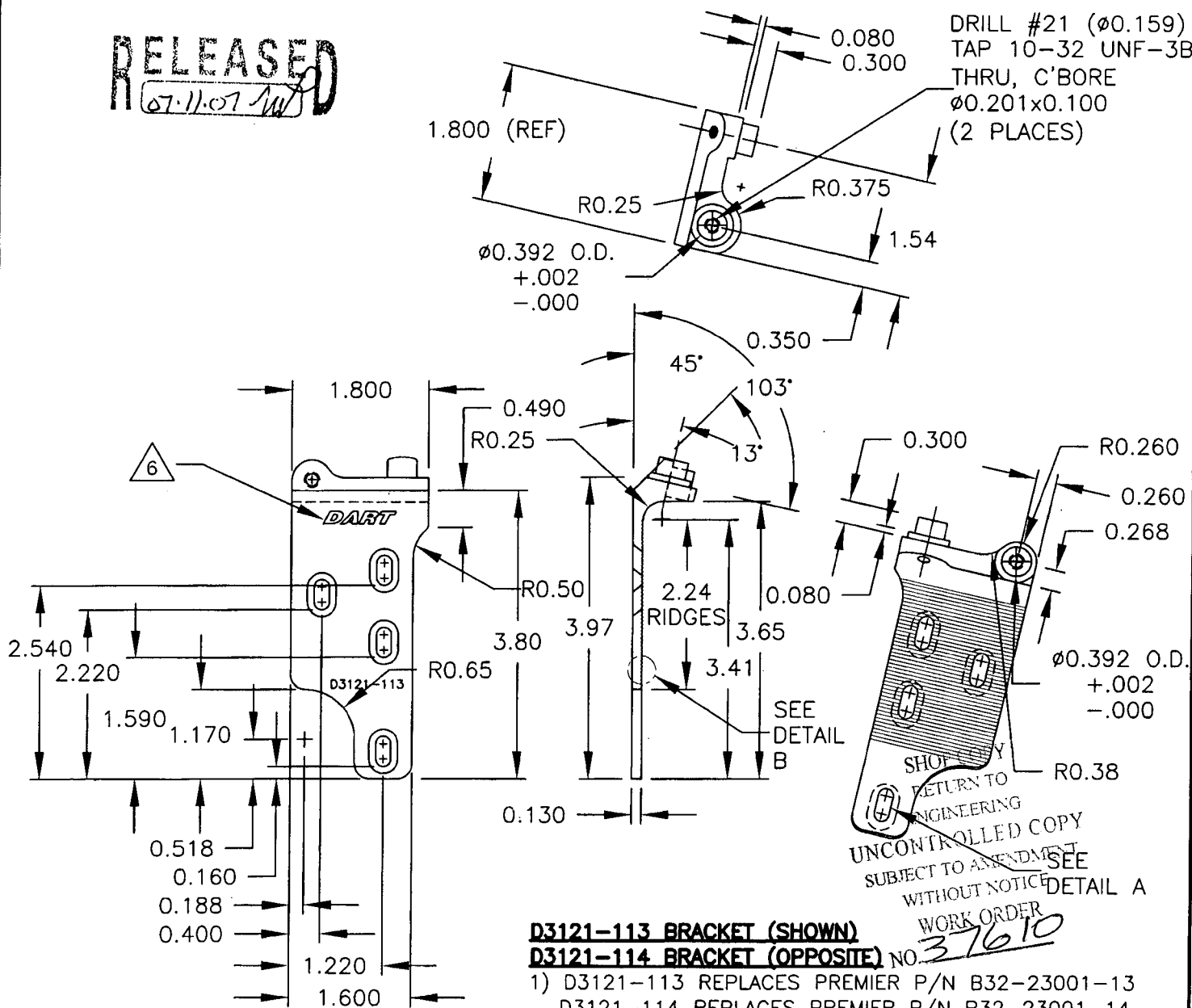
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07-11-07



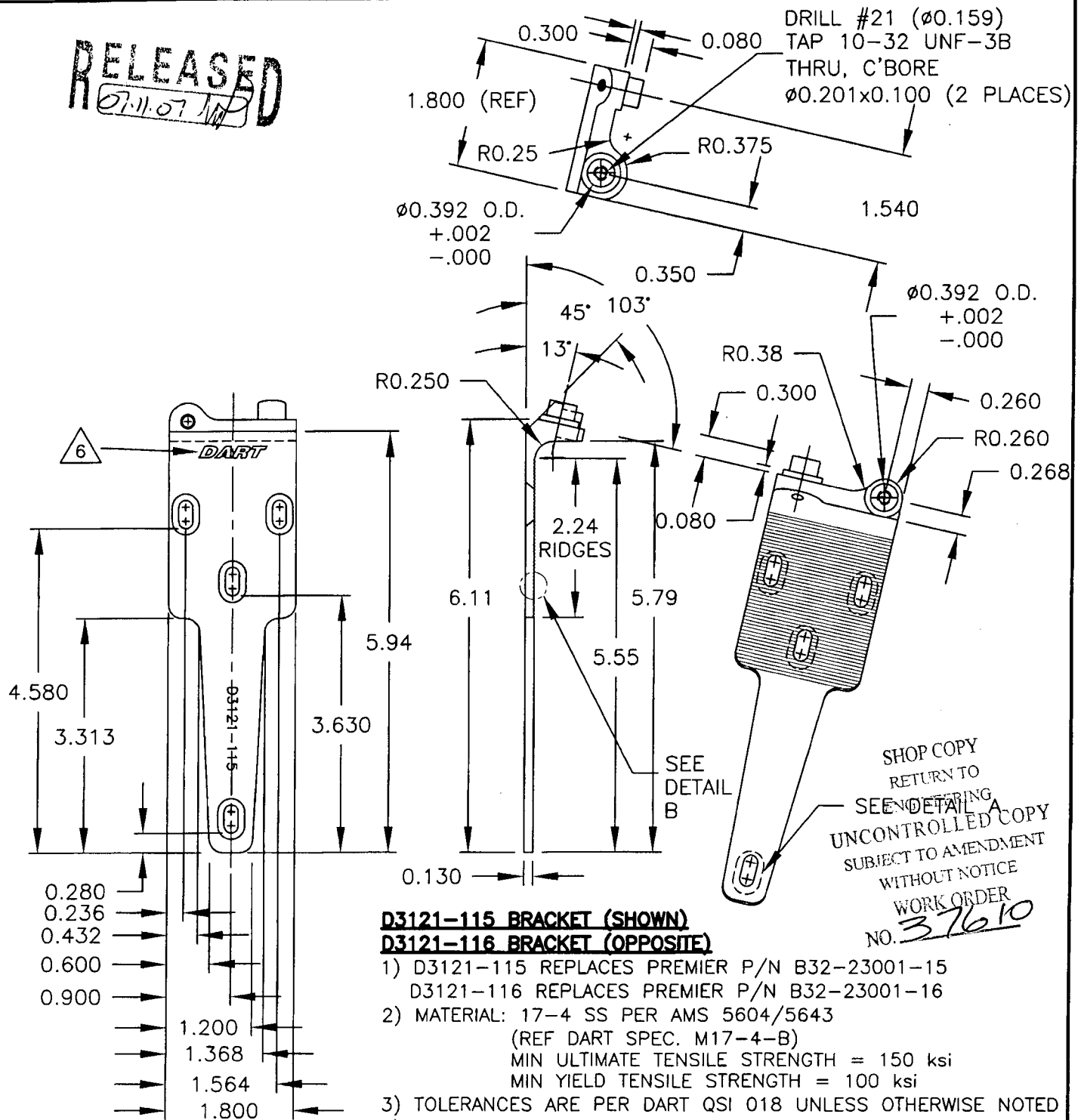
- D3121-113 BRACKET (SHOWN)** WORK ORDER NO. 37610
D3121-114 BRACKET (OPPOSITE) NO. 37610
- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
 D3121-114 REPLACES PREMIER P/N B32-23001-14
 - 2) MATERIAL: 17-4 SS PER AMS 5604/5643
 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
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 - 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
 - 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

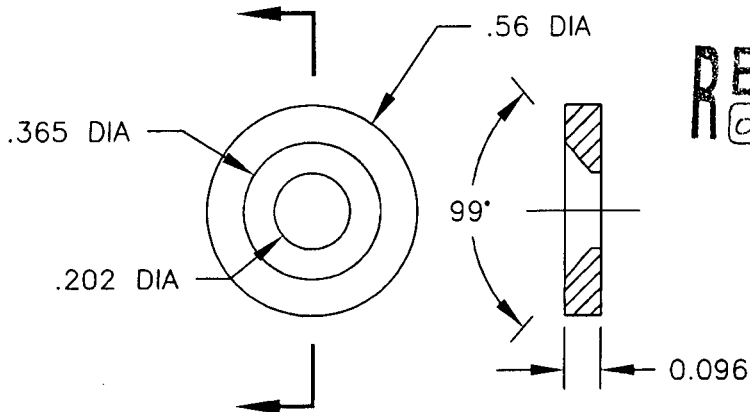
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
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- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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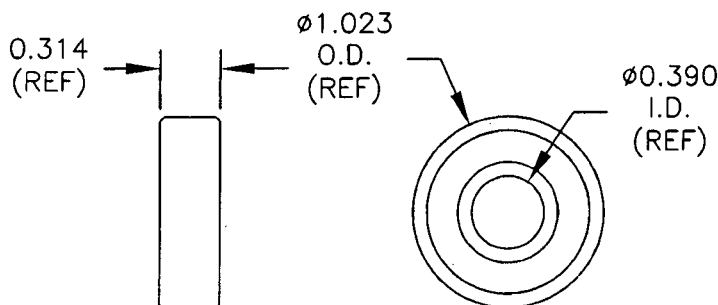
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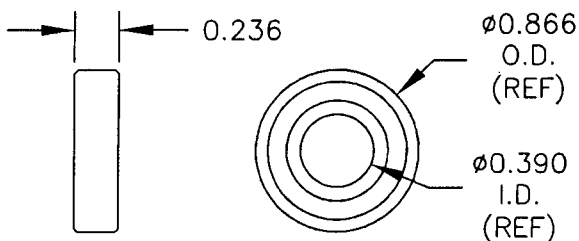
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

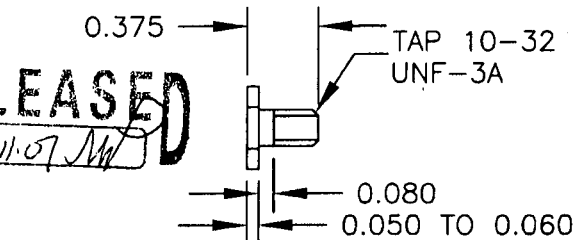
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

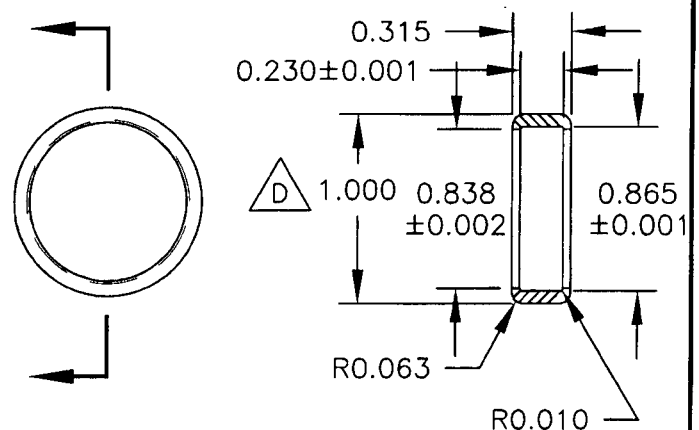
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

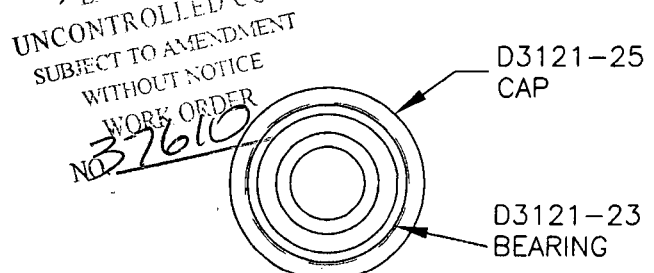
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-ZZ OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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